

Date: Thursday, 10/18/2007 8:03:09 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 35207	
Estimate Number : 10314	
P.O. Number :	Part Number : D265613
This Issue : 10/18/2007 S.O. No. :	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : SMALL /MED FAB	Drawing Revision : D.
Previous Run : 33419	Material :
Written By :	Due Date : 11/4/2007 Qty: 30 Um: Each
Checked & Approved By : <u>10/07/10.18</u>	
Comment : Est: F 02.10.25 Re-format KJ/RF	
Est Rev:G Now on Waterjet 06-07-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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27.2000



Comment: Qty.: 0.8500 sf(s)/Unit Total : 25.5000 sf(s)
1010/1025/A21/6aA SHEET

106069 IB 07-10-31

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D2656
Dwg Rev: D
Prog Rev: D

IB 07-10-31

(32)

2-Deburr if necessary IB 07-10-31

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 07-10-31



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



counter

Comment: SECOND CHECK

Es 09/11/01

(32)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326
2-Form joggle as per Dwg D2656 using Jig DT8158Identify as D2656-13

07/11/13 (32)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:03:09 AM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 35207

Part Number: D265613

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



07.11.13 (32)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



M105642



(32X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m.f. 07/11/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/11/14 (32)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(32X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP 17*

m.f. 07/11/14

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.15

Job Completion



u 07.11.14

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

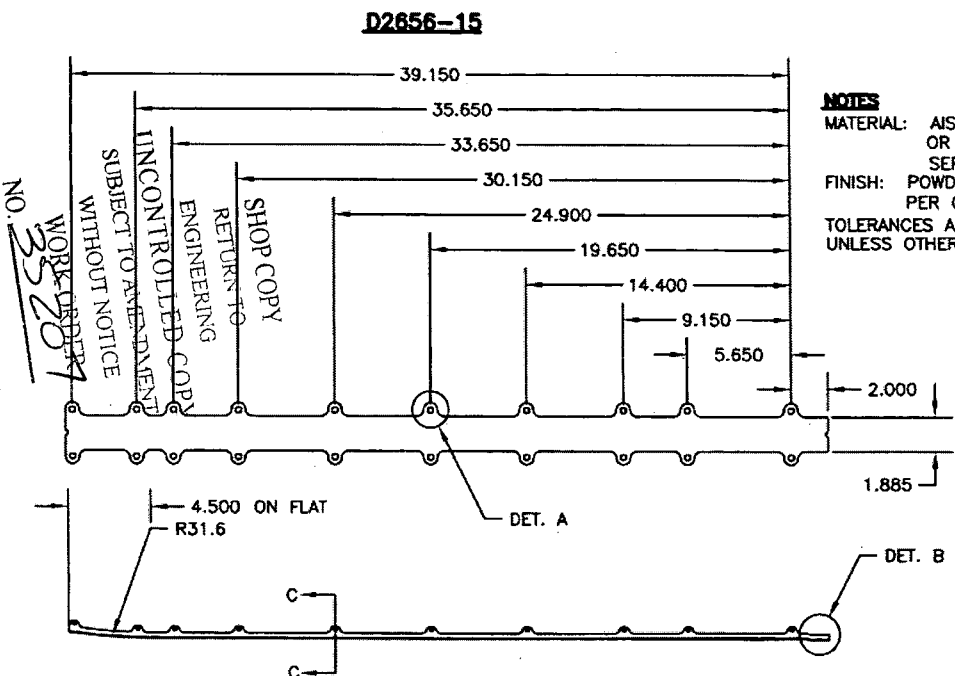
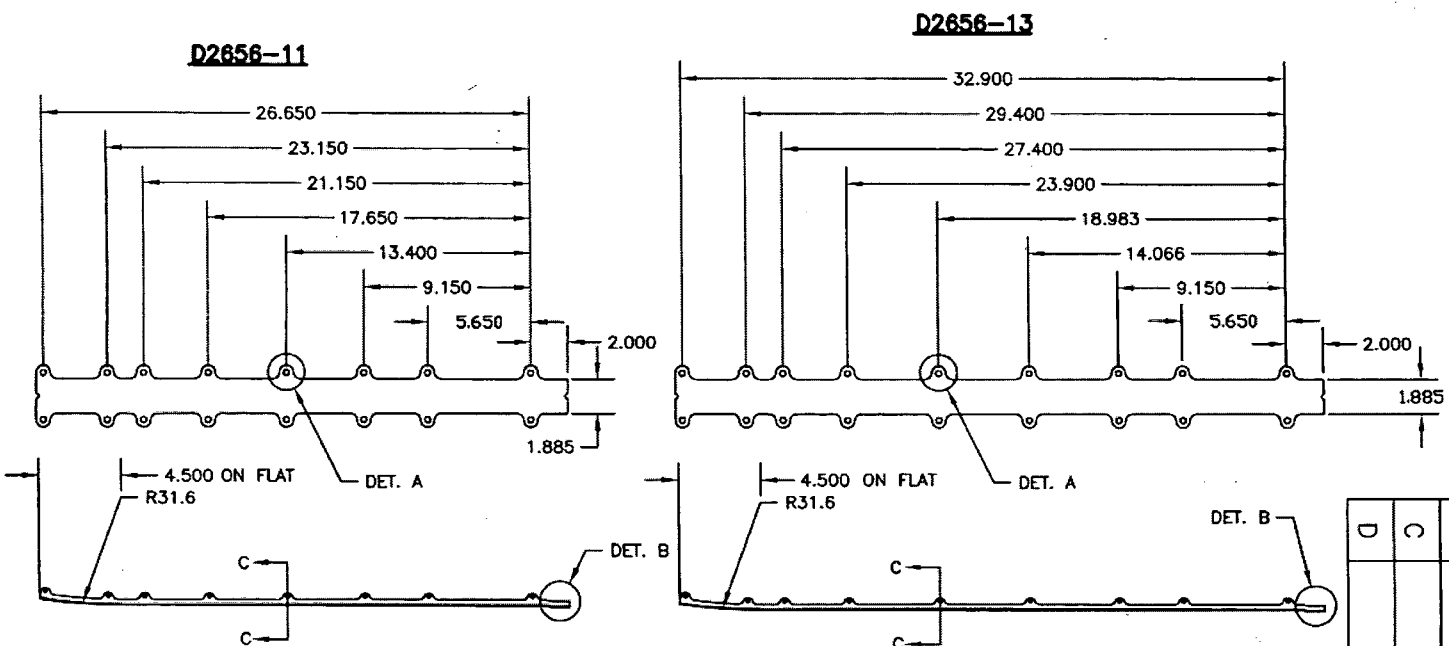
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



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DS	CP		
CHECKED	APPROVED	DRAWING NO.	REV. D
<i>[Signature]</i>	<i>[Signature]</i>	D2656	SHEET 1 OF 4
DATE	TITLE		SCALE
05.08.17	WEARSHOE		1:10
A	97:03:25	NEW ISSUE	
B	97:06:02	CHANGED TABS	
C	97:06:26	R31.6 WAS R19.5	
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT	



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASE
2010-50
05-09-84

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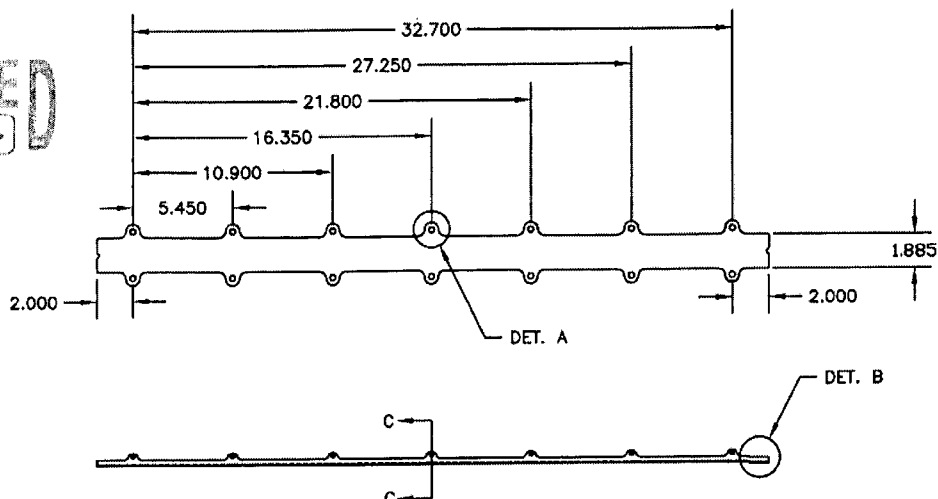
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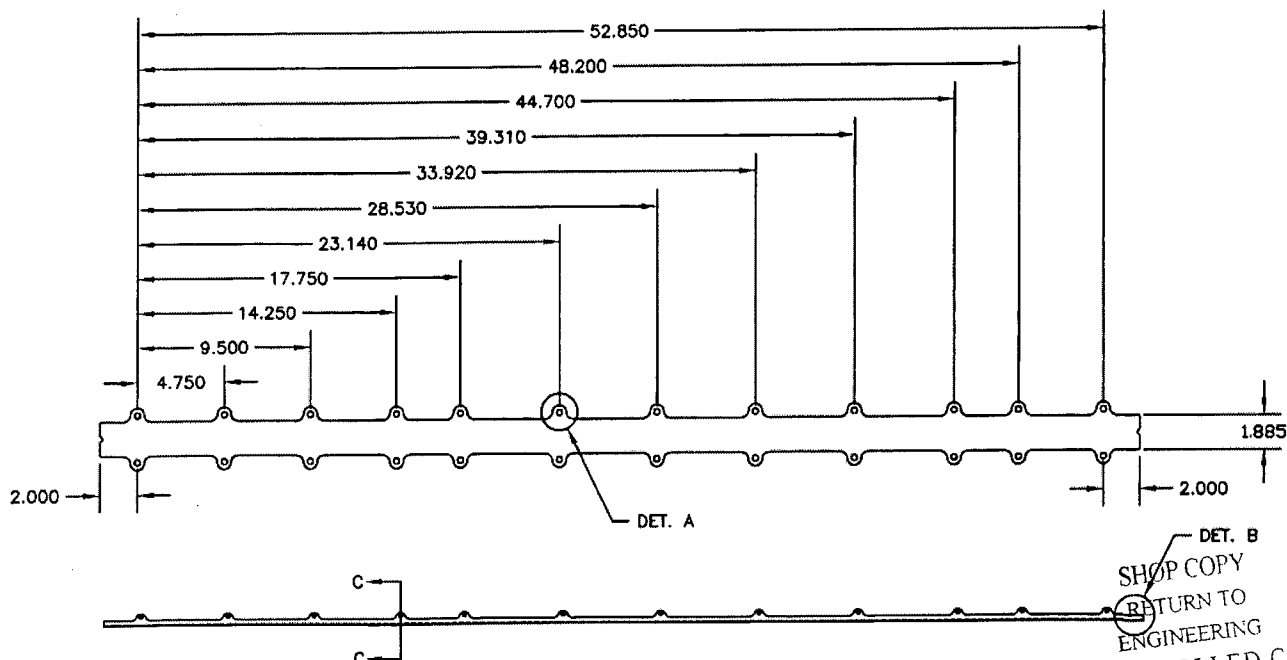
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

RELEASED
DS 07-06 *[Signature]*

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
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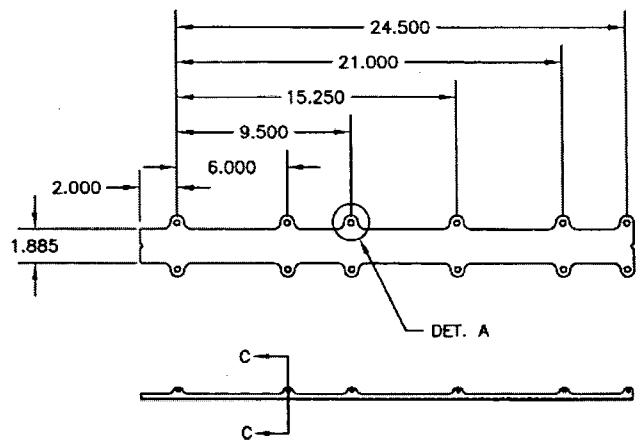
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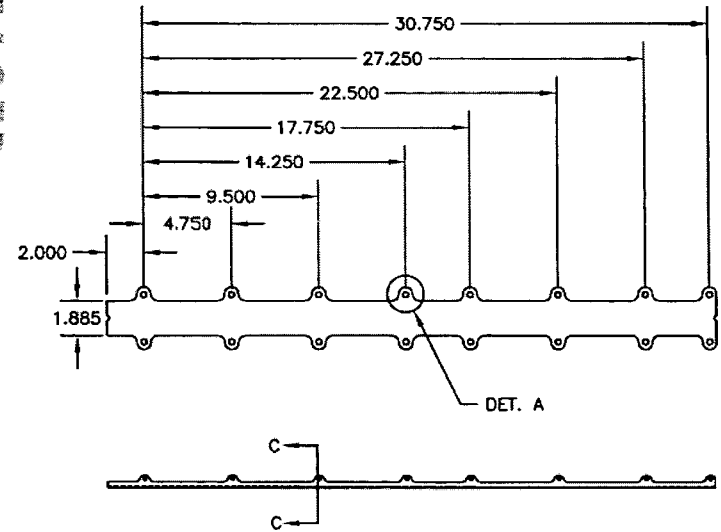


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		TITLE	WEARSHOE	SHEET 3 OF 4
				SCALE
				1:10

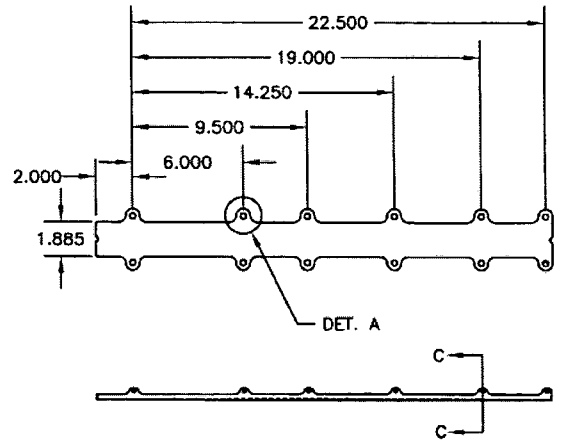
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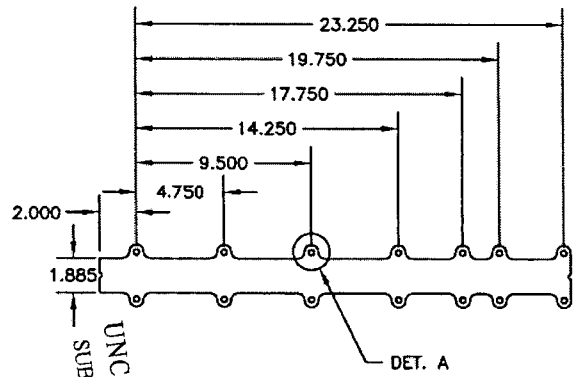
D2656-37



D2656-31



D2656-35



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05.07.06

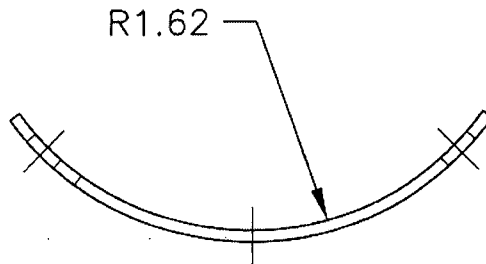
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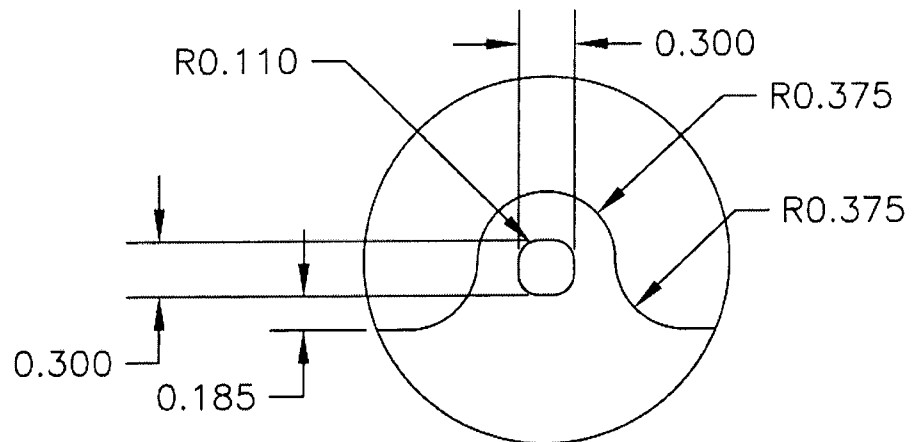
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

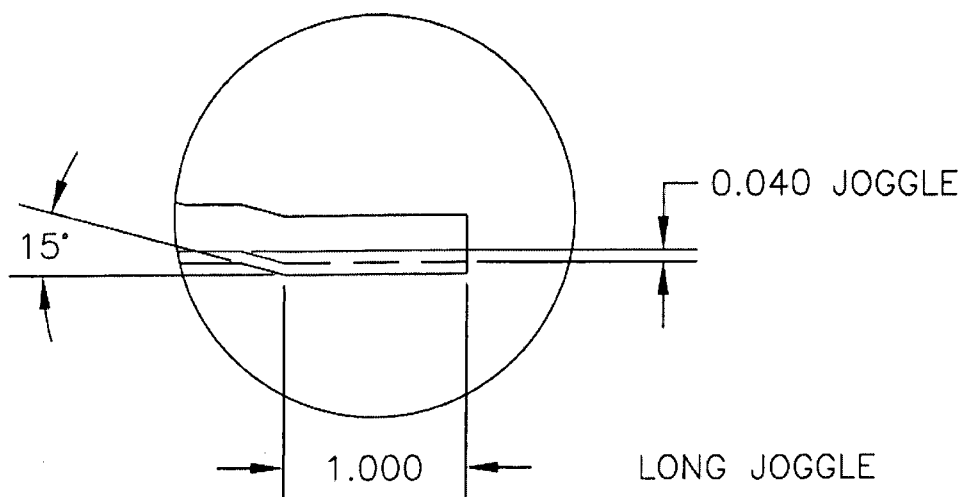


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05.09.06

DETAIL A



DETAIL B



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